

Date: Friday, 2/23/2007 8:32:22 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 30899				
Estimate Number	: 10710				
P.O. Number	: N/A		Part Number	: D32111	
This Issue	: 2/23/2007	S.O. No. : N/A	Drawing Number	: D3211 REV A1	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A1	
Previous Run	: 29553		Material	: N/A	
Written By			Due Date	: 3/14/2007	
Checked & Approved By			Qty:	10 Um: Each	
Comment	: Est Rev:A New Issue 05-11-17 JLM				
	Est Rev:B Now on Waterjet 06-10-24 JLM				
Additional Product					
Job Number: 					
Seq. #:	Machine Or Operation:	Description :			
1.0	M2024T3S063	2024-T3 .063 sheet 			
Comment: Qty.: 1.4753 sf(s)/Unit Total : 14.7525 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)Identify as D3211-1 Batch: M102942 M103321④ SAD 07/02/28					
2.0	WATER JET	FLOW WATER JET 			
Comment: FLOW WATER JET 1-Cut as per Dwg D3211 Dwg Rev: A Prog Rev: A 2-Deburr if necessary SAD 07/02/28 10					
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/02/28 10					
4.0	QC8	SECOND CHECK 			
Comment: SECOND CHECK 07/02/28 10					
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr SAD 07/03/05 10					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:32:23 AM
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Drawing Name: BRACKET

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Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

SB 07/03/14

10

7.0 QC5

INSPECT WORK TO CURRENT STEP



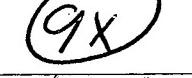
07/03/14 (9)

(Pc)

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m.l

07/03/15

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ml 07/03/15

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 POWDER COATING

POWDER COATING



M100700

(9x)

(9x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m.l

07/03/15

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/15 (9x) 10

12.0 QC21

FINAL INSPECTION/W/O RELEASE



(9)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/15

Job Completion



U 07.03.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3211-1 PAR #: N/A Fault Category: Prod / FAB. Ass. ^{med & small} NCR: Yes No DQA: D Date: 07/03/19
 QA: N/C Closed: A Date: 07.03.19

NCR: 30899.		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/19	2.0	Grain wrong grain direction 6 parts	<u>J</u> QSC042	Scrap & destroy Replace.	SAD 07/02/19	<u>J</u> 07.02.19	<u>J</u> QSC042	<u>J</u> 07.02.19
07/03/19	6.0	Part cracked from bending.	<u>J</u> QSC042	Scrap & destroy	8B 07/03/19	<u>J</u> 07.03.19	<u>J</u> QSC042	<u>J</u> 07.03.19

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30899
Description: Bracket	Part Number:	D3211-1
Inspection Dwg: D3211 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAD	Audited by:	MS	Prototype Approval:	N/A
Date:	07/02/28	Date:	07/02/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	FF

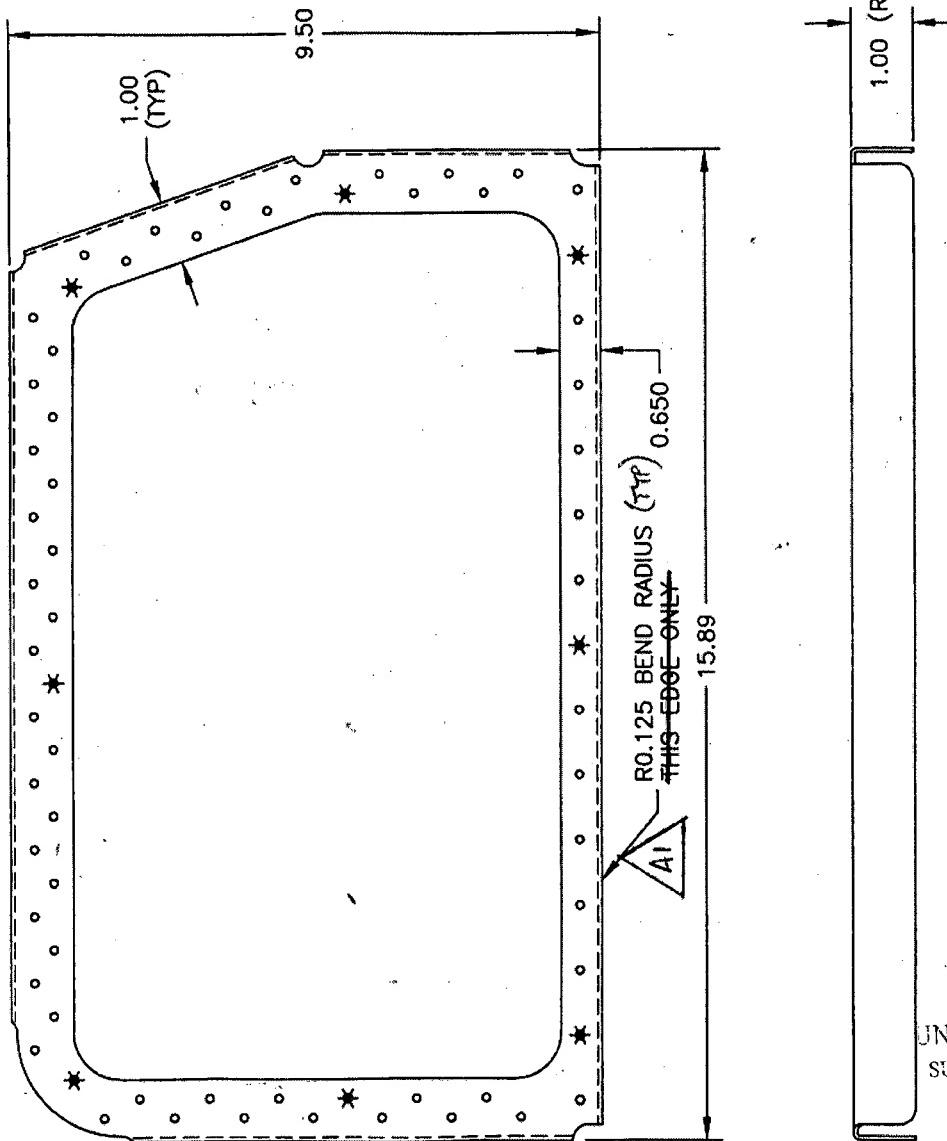
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3211	SHEET 1 OF 2
DATE		TITLE	SCALE
03.09.03		BRACKET	1:3
A	03.09.03	NEW ISSUE	
A1	03.12.05	CHANGE ALL BEND RADIUS TO R0.125	

RELEASED

03.09.15

D3211-1 BRACKET
 MACHINE PER DRAWING FILE "D3211-A2.DWG"
 CHECK PER TEMPLATE D3211-1T1
 MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
 FINISH: ACID-ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 USE MINIMUM BEND RADIUS OF 0.125" EXCEPT WHERE INDICATED 0.125"
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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 WORK ORDER
 NO. 30899

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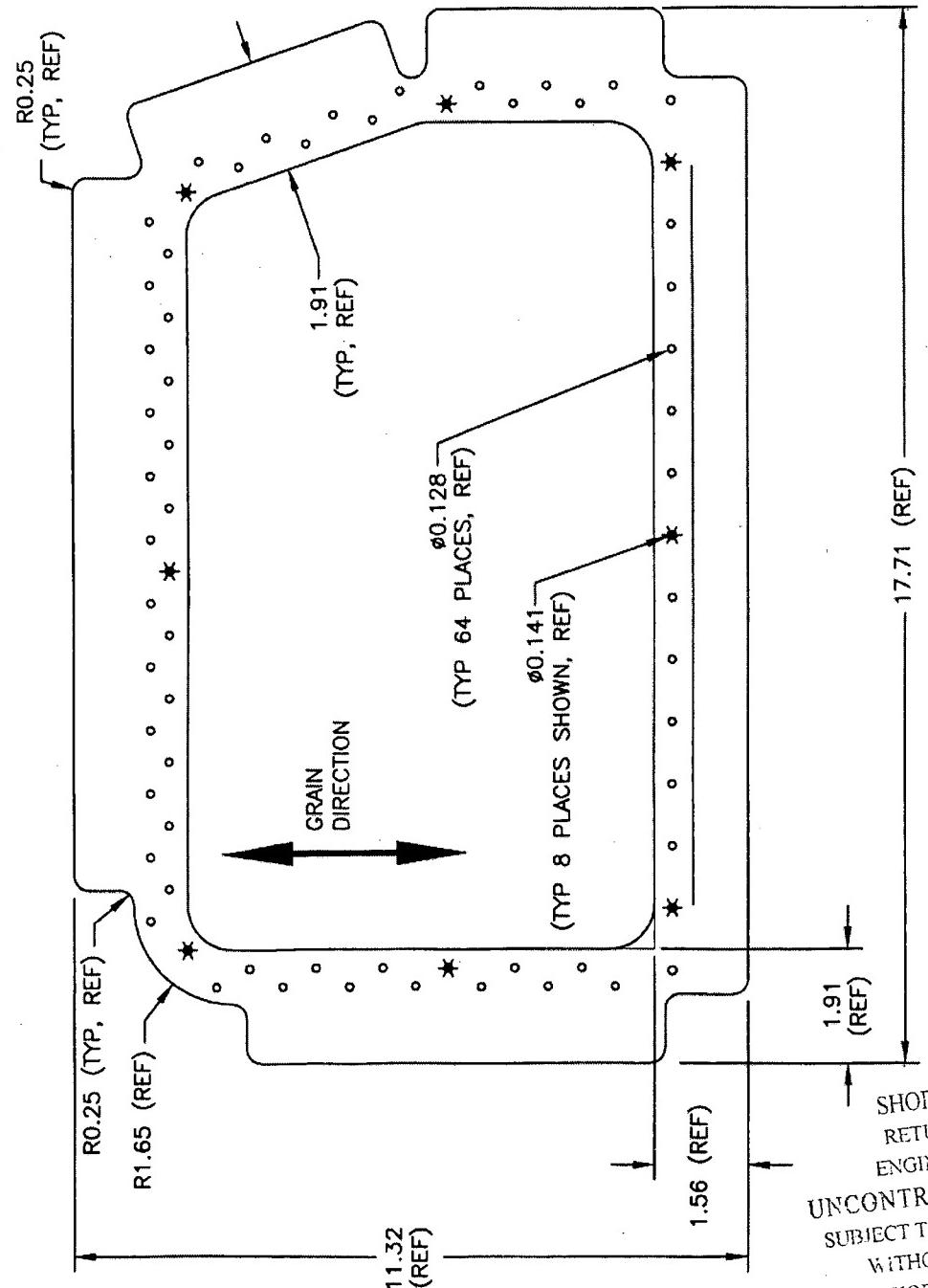
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	03.09.03	D3211	SHEET 2 OF 2

RELEASED
03.09.03

D3211-1 FLAT PATTERN



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